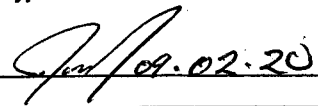











Date: Friday, 20/02/2009 9:23:51 AM  
User: Jean-Luc Menard

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)	
<b>Job Number</b> :	45924	<b>Part Number</b> :	D2574	
<b>Estimate Number</b> :	10534	<b>Drawing Number</b> :	D2574 REV E	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	20/02/2009	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	E	
<b>First Issue</b> :	//	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :	44205	<b>Material</b> :		
<b>Written By</b> :			<b>Due Date</b> :	27/02/2009
<b>Checked &amp; Approved By</b> :			<b>Qty:</b>	20
<b>Comment</b> :	: Est Rev: I As Per RevE 06-01-27 JLM		<b>Um:</b>	Each

## Additional Product

Job Number:			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	D6101005	Saddle Billet	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>834874</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>45924</u> Double check by: <u>DTF</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
			
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE			

Date: Friday, 20/02/2009 9:23:51 AM  
User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 45924

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/04 (20)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 09-03-04 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939

START TIME:

8:30AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:00AM

9/03

09-03-04

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

fd 09/03/05 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57434

09/03/06

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/03/08

Job Completion



NF  
09-03-06

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>45924</b>
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b>	<b>D2574</b>
<b>Inspection Dwg: D2574 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.7500	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.000	8.000		
F	0.490	0.510		.498	.504	.497	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.376		
I	0.490	0.510		.493	.497	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.562	.560	.560	.560		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.127	.135	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.245	.240	.247	.243		
W	0.115	0.135		.131	.130	.125	.125		
X	0.307	0.312		.312	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.368	.370	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.628	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.509	1.509	1.508		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.267	.268	.268	.270		
AH	0.240	0.260		.253	.250	.254	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>SP</i>
Date:	09/02/26

Audited by:	<i>J.F</i>
Date:	09/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	45924
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b>	D2574
<b>Inspection Dwg: D2574 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5X	C2	73	84		
A	0.438	0.443		.440	.440	.438	.440		
B	1.745	1.755		1.752	1.748	1.749	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.493	.495	.500	.506		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.571	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.377	1.377	1.377	1.377		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.120	.130	.130	.130		
Q	0.115	0.135		.130	.135	.135	.135		
R	0.240	0.260		.255	.252	.252	.252		
S	0.115	0.135		.130	.130	.125	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.236	3.236	3.236		
V	0.230	0.250		.238	.242	.244	.245		
W	0.115	0.135		.125	.123	.120	.119		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.370	.367	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.623	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.512	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.254	.252	.253	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <u>88</u> <u>mmf</u>
Date: <u>09/02/27</u> <u>09/02/28</u>

Audited by: <u>J.F.</u>
Date: <u>09/03/04</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 45924
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.001	8.002	8.001		
F	0.490	0.510		.498	.495	.497	.495		
G	0.257	0.262		.259	.260	.260	.260		
H	0.375	0.380		.376	.375	.375	.375		
I	0.490	0.510		.499	.499	.499	.502		
J	1.174	1.184		1.178	1.177	1.177	1.177		
K	0.558	0.578		.567	.565	.570	.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.368	1.368	1.370		
N	2.495	2.505		2.499	2.495	2.497	2.495		
O	4.119	4.129		4.122	4.120	4.121	4.122		
P	0.115	0.135		.128	.128	.130	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.251	.252	.251		
S	0.115	0.135		.125	.125	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.245	.243	.243		
W	0.115	0.135		.121	.125	.125	.125		
X	0.307	0.312		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.372	.371	.372		
AA	0.470	0.530		.500	.500	.498	.500		
AB	0.615	0.635		.624	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.512	1.500	1.501	1.508		
AF	0.115	0.135		.135	.133	.135	.135		
AG	0.240	0.280		.260	.270	.270	.270		
AH	0.240	0.260		.252	.255	.251	.251		
AI	2.000	2.020		2.001	2.001	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: mwf
Date: 09/03/01

Audited by: J-F.
Date: 09/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	45924
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b>	D2574
<b>Inspection Dwg: D2574 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 13	2 14	3 15	4 16	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.498	3.499	3.498	3.490		
D	1.745	1.755		1.748	1.747	1.748	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		.495	.500	.495	.498		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.376	.376	.376	.377		
I	0.490	0.510		.500	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.570	.569	.569	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.368	1.369	1.366	1.372		
N	2.495	2.505		2.498	2.497	2.497	2.495		
O	4.119	4.129		4.121	4.120	4.121	4.124		
P	0.115	0.135		.130	.129	.130	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.251		
S	0.115	0.135		.126	.126	.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.229	3.230	3.228		
V	0.230	0.250		.241	.244	.246	.244		
W	0.115	0.135		.120	.120	.120	.120		
X	0.307	0.312		.312	.311	.311	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.366	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.508	1.510	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.253	.255	.265		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.003	2.000	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	09/03/02

Audited by:	J.F.
Date:	09/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 45924
<b>Description: Saddle, Aft Inboard</b>	<b>Part Number:</b> D2574
<b>Inspection Dwg: D2574 Rev. E</b>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 17	2 18	3 19	4 20		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.748	1.748	1.748		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.499	.500	.500	.499		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.502	.500	.501		
J	1.174	1.184		1.1748	1.1748	1.1748	1.1748		
K	0.558	0.578		.572	.572	.572	.570		
L	1.174	1.184		1.1748	1.1748	1.1748	1.1748		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.494	2.495	2.495	2.494		
O	4.119	4.129		4.128	4.122	4.120	4.122		
P	0.115	0.135		.126	.126	.128	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.252	.251		
S	0.115	0.135		.126	.125	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.231	3.233	3.232	3.232		
V	0.230	0.250		.247	.247	.248	.249		
W	0.115	0.135		.119	.119	.119	.116		
X	0.307	0.312		.312	.312	.312	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.371	.370	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.508	1.509	1.510	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.264	.265	.265	.265		
AH	0.240	0.260		.251	.251	.251	.253		
AI	2.000	2.020		2.001	2.001	2.001	2.000		
AJ	0.023	0.043		.032	.033	.033	.033		
Accept/Reject									

Measured by: <i>mmf</i>
Date: 09/03/02

Audited by: J.F.
Date: 09/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

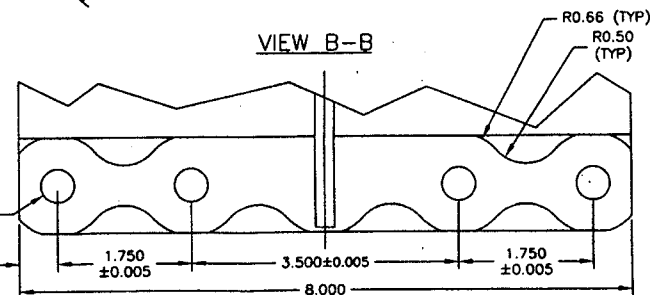
# NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKBURY, OXFORD, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	02574
DATE	05.07.13	TITLE	INNER AFT SADDLE		

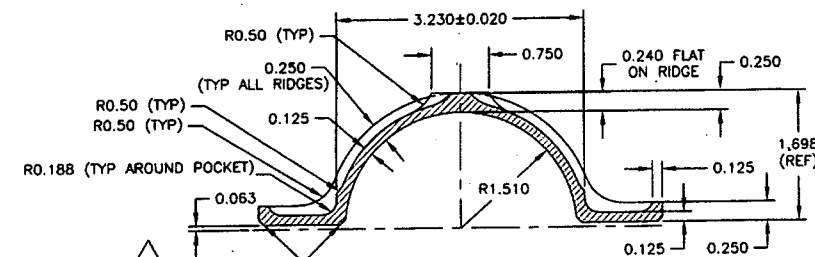
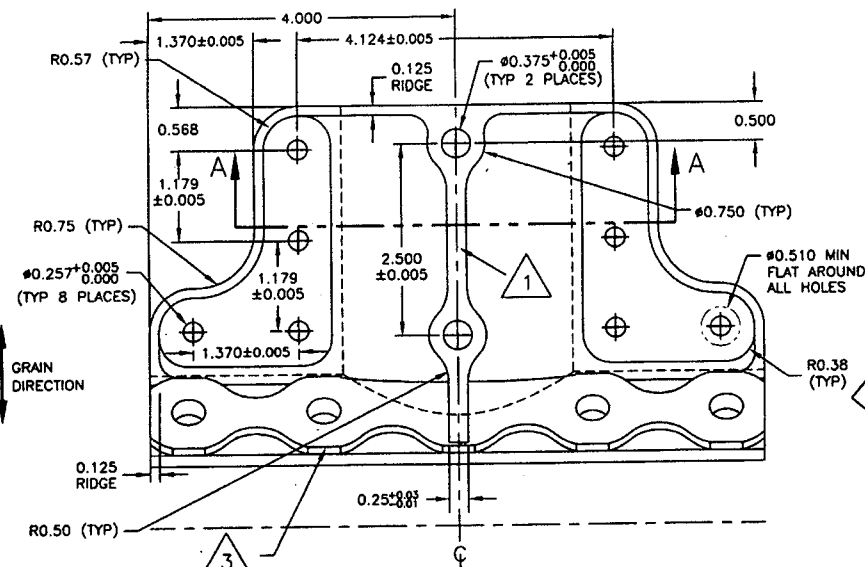
REV. E  
SHEET 1 OF 1  
SCALE  
2:3

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DETAIL C  
SCALE 2:1

4  
(TYP)



## SECTION A-A

*Handwritten note:* 12/05/06